

Work Order ID 82387

82387

Page 1

March-30-12 7:46:41 AM

Item ID: D2804-042 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bracket Assembly
 Start Date: 29/03/2012 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 12/04/2012 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/03/30 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2804	Rev C								

100
100
 Small Fab
 Small Fab
 Small Fab
 Small Fab
 Small Fab
 Memo
 Press D2805-2 into arm as per Dwg D2804

0.00
 0.00
 0.00

(3x)

12/04/17

110
110
 QC
 Quality Control
 QC5- Inspect part completeness to step on W/O
 Memo
 Quality Control

0.00
 0.00

5/12/17

(x3)

-042

120
120
 Powdercoat
 Powder Coating
 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum
 Memo
 START TIME: 2:10 OVEN TEMPERATURE:
 FINISH TIME: 2:40

0.00
 0.00

3x

✓

12/04/17

m 12/134

3200F

2:40

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 82387

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Item ID: D2804-042

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Bracket Assembly

Stop ***NS2***

Start Date: 29/03/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 12/04/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC3- Inspect Part Finish	0.00							
130									
QC	Memo	0.00				3	0		BL D-4-17
Quality Control									
140		0.00							
140	Small Fab								
Small Fab	Memo	0.00				5	0		12/04/18
Small Fab	Press Fit D2809 as per Dwg D2804								
150		0.00							
150	Small Fab								
Small Fab	Memo	0.00				3x	0		12/04/18
Small Fab	1-Spray LPS-3 on Bolt Shaft, not on thread as per Dwg D2804 2-Assemble as per Dwg D2804.								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Item ID: D2804-042

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Bracket Assembly

Stop ***NS2***

Start Date: 29/03/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 12/04/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00

160

QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: **ST 50** 0.00***170***

Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

(83)

-042

3x

SD
12-04-18

12/4/19

12-04-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March-30-12 7:46:45 AM

Page 1

Work Order ID: 82387

82387

Parent Item: D2804-042

D2804-042

Parent Item Name: Bracket Assembly

Start Date: 29/03/2012

Required Date: 12/04/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP F05.03.30MS21043-3 was MS21042L3 KJ/JLM
IPP Rev:G As per Rev C 06-11-08 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2804-2		Manufactured	No			100	Each	3.0000	1	4			
D2804-2									**				
Bracket													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST149		3							
				79180		3							
D2805-2		Manufactured	No			100	Each	0.0000	1	4			
D2805-2													
Stop													
NAS1515H3		Purchased	No			100	Each	194.0000	4	16			
NAS1515H3									**				
Washer													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST277		194							
				118078		6							
				118384		11							
				119438		4							
				120142		47							
				120518		26							
				120770		100							
AN3C16A		Purchased	No			150	Each	65.0000	2	8			
AN3C16A									**				
Bolt													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST352		65							
				115835		1							
				118422		4							
				120498		60							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 82387

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Parent Item: D2804-042

D2804-042

Parent Item Name: Bracket Assembly

Start Date: 29/03/2012

Required Date: 12/04/2012

Start Qty: 4.00

Required Qty: 4.00

D2809

Manufactured No

150

Each

51.0000

1

4

D2809

Bushing

**

LP 12/04/18

Location

Loc Qty

Loc Code

GA

35

72735

7

80557

28

ST018

16

34035

12

77292

4

MS21043-3

Purchased

No

150

Each

613.0000

2

8

MS21043-3

Nut

**

LP 12/04/18

Location

Loc Qty

Loc Code

FG

72

103691

72

GA

270

120693

270

ST301

271

118077

2

118614

219

118686

30

119758

20

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector



Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

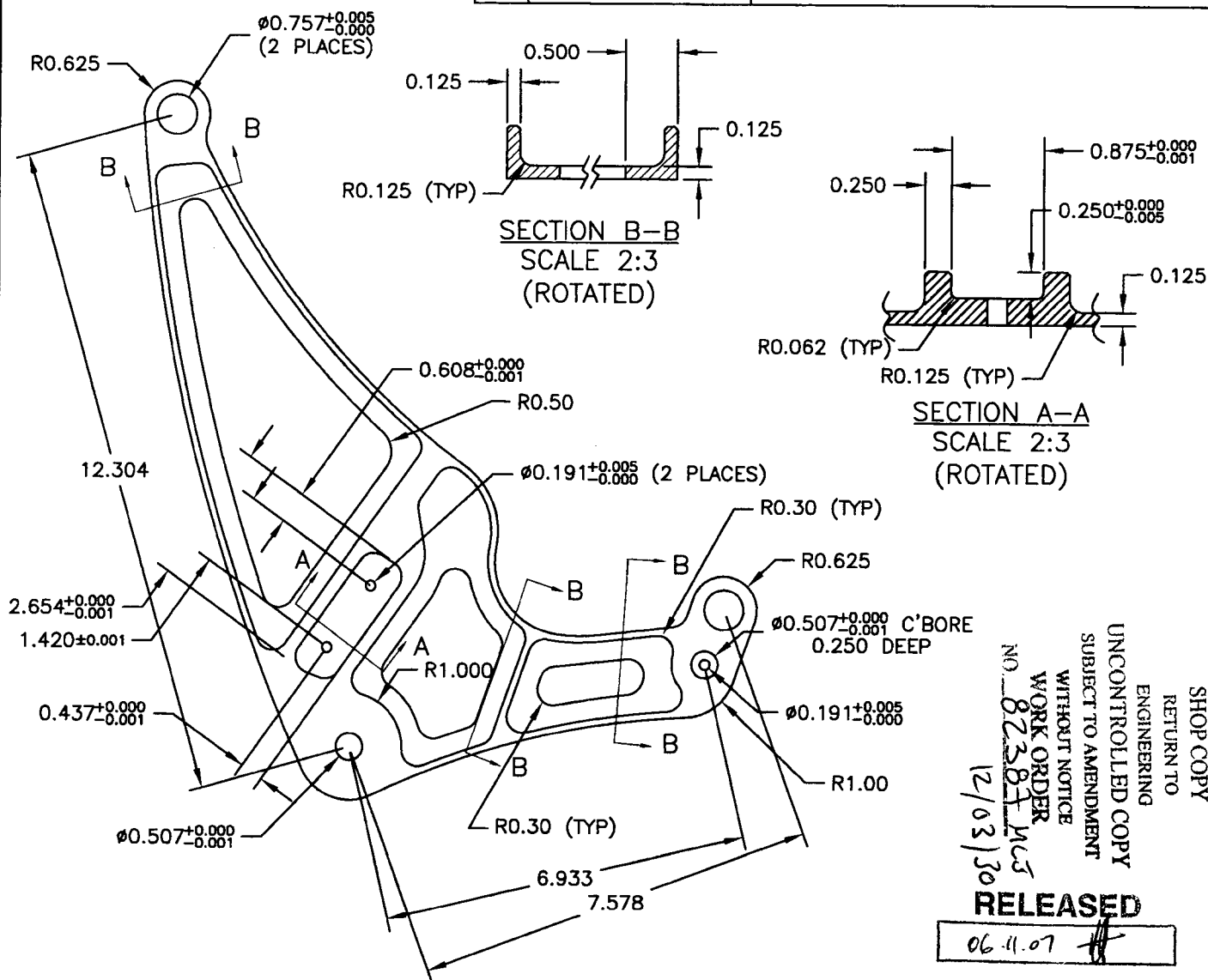
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

DART

DESIGN CP		DRAWN BY CP		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 		APPROVED 		DRAWING NO. D2804	REV. C SHEET 1 OF 2
DATE 06.10.16			TITLE STA 155 BRACKET SCALE 1:3		
A	00.11.07		NEW ISSUE		
B	04.11.22		ADD CUTOUTS & -043/-044		
C	06.10.16		CHANGE GEOM. TO ADD CLEARANCE		



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 82387 MGS
12/03/30
RELEASED

06.11.07

D2804-1 BRACKET (SHOWN). D2804-2 BRACKET (OPPOSITE)

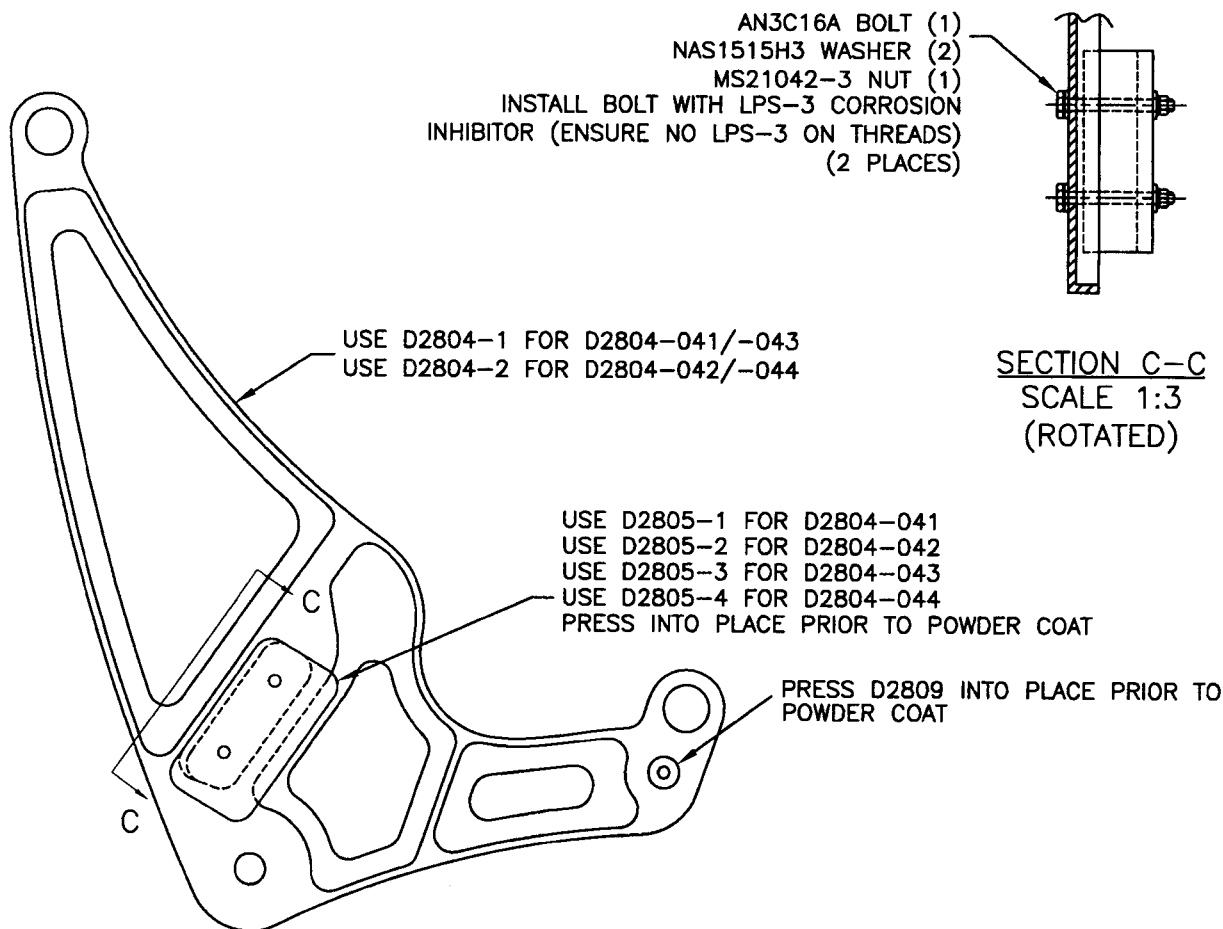
- 1) MACHINE PER DRAWING FILE "D2804-1C.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D2804	REV. C SHEET 2 OF 2
DATE 06.10.16		TITLE STA 155 BRACKET	SCALE 1:3



02307
RELEASED

D2804-041/-043 BRACKET ASS'Y (SHOWN).
D2804-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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